

731011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:39:57 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MECHANICAL GROUND HANDLING WHEEL KIT	
Job Number :	47364B			
Estimate Number :	12140			
P.O. Number :		Part Number :	D206731042	
This Issue :	22/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	DSK 093 REV B	
First Issue :	//	Project Number :	N/A	
Previous Run :	47363B	Drawing Revision :	B	
Written By :		Material :		
Checked & Approved By :	JUD 09.04.22	Due Date :	05/06/2009	Qty: 1 Um: Each
Comment :	est rev. A 01.02.01 new issue EC Est Rev:B As per Rev b 07-02-13 JLM est rev C 07.05.14 rev C IIN ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	B44058

Pl 09.04.30

✓ 2.0	D3353042	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3353-042	LUG ARM WELDMENT	B37787

Pl 09.04.30

✓ 3.0	D3354042	Mirror Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-042	Left Arm Weldment	B36214

Pl 09.04.30

✓ 4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RIGHT ARM WELDMENT

batch: B42477

Pl 09.04.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/04/2009 11:39:57 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 47364B

Part Number: D206731042



Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 5.0 D33561 Pin

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
pick:
qty Part Number Description batch
1 D3356-1 pin R36640

Pl 09.04.30

✓ 6.0 D3397041 Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
pick:
qty Part Number Description batch
2 D3397-041 Wheel ass'y R36529

SAD 09.05.13

✓ 7.0 113800 GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
pick:
qty Part Number Description batch
1 113-800 GREASE FITTING M109564

Pl 09.04.30

✓ 8.0 656051 flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
pick:
qty Part Number Description batch
2 656-051 flat washer M109735

Pl 09.04.30

✓ 9.0 663079 Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
pick:
qty Part Number Description batch
1 663-079 Lock washer M16362

Pl 09.04.30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 47364B

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	M19278

PL09.04.30

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	M110523

PL09.04.30

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
pick:

qty	Part Number	Description	batch
2	CP-21	1/8" Cotter Pin 2" long	M108200

PL09.04.30

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	M109840

PL09.04.30

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	M102395

PL09.04.30

W/O:		WORK ORDER CHANGES					
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Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 47364B

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

M16588

plc 09-04-30

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

M16362

plc 09-04-30

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

SAD 09-05-13

plc 09-04-30

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-05-15

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD47364

SAD 09-05-15

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/19

Job Completion



MF 09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

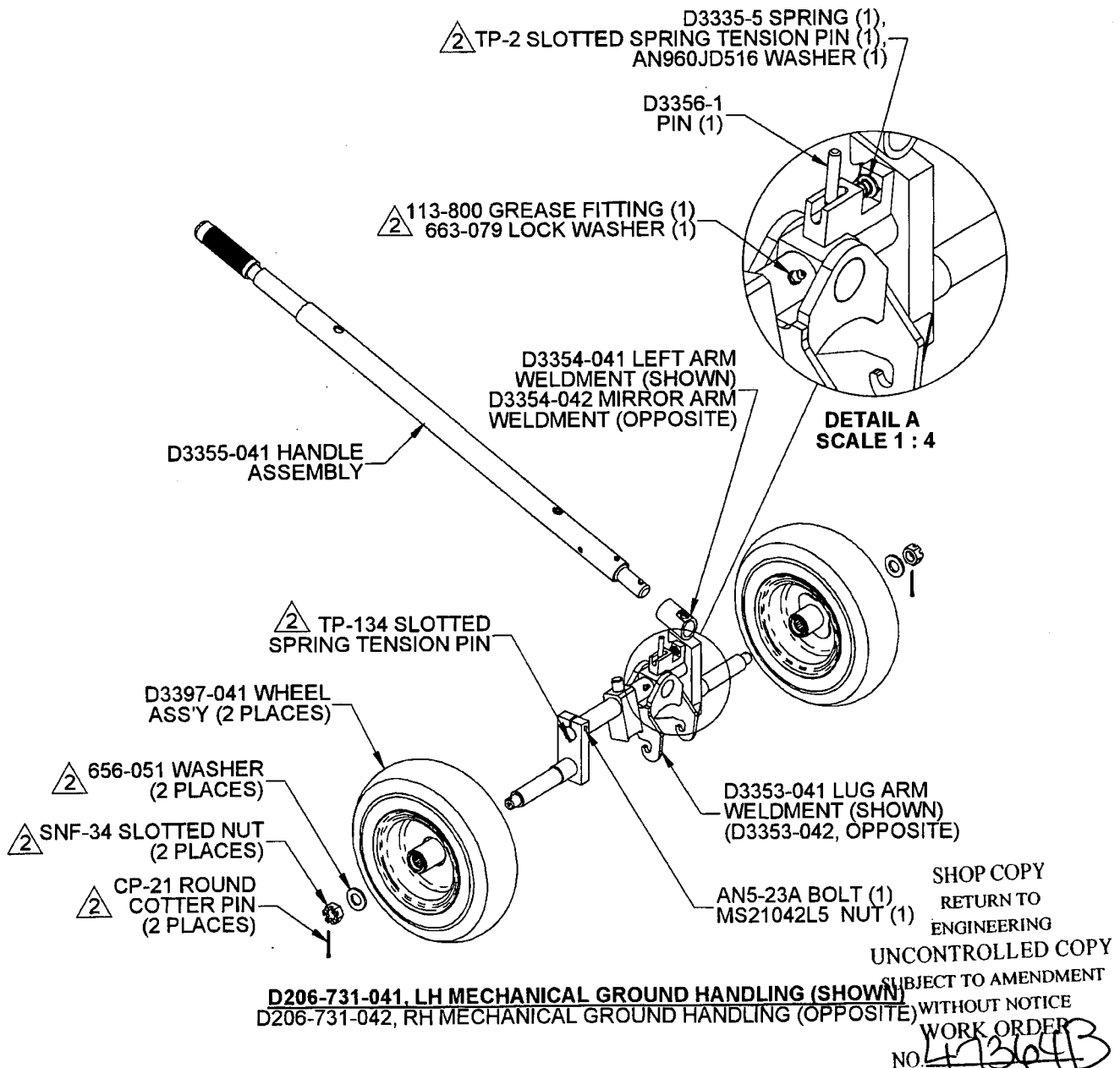
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.02.05

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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